WHAT IS CLAIMED IS:

1. A method for cutting metal, comprising:

heating a metal locally to a molten state;

removing the molten metal from the local area using pressurized gas;

directing the molten metal away from the operator, but on the same side of the metal to which heat was first applied;

adjusting at least one of the position and strength of the heat source with relation to the molten metal so the molten metal flows out of the local area making a cut; and

moving the cutting torch in a direction generally parallel to a desired cut line to expand the cut line.

2. A method for cutting metal according to claim 1, wherein a cutting trench is created when the molten metal is removed from the area.

3. A method for cutting metal according to claim 1, wherein adjusting the position and strength of the heat source comprises varying the distance from the cutting tip to the metal and the flow rate of the oxygen.

4. A method for cutting metal according to claim 1, wherein heating a metal locally to a molten state comprises making the metal almost molten, adding additional pressurized gas causing the metal to become molten.

5. A method for cutting metal, comprising:

heating metal locally to a molten state by holding a cutting torch generally perpendicular to the surface where the cutting torch has a two-part tip which releases both a combustible gas and a combustion enhancing gas and generally in the same direction and has a control means for gradually changing gas pressures;

directing the gases at the molten metal at an angle of incidence (α_i) with a horizontal plane of the molten metal of at least about 45 degrees and increasing the flow rate of the combustion enhancing gas thereby removing the molten metal from the local area creating a cutting trench;

maintaining an angle of incidence (α_i) of at least about 45 degrees to remove the molten metal from the cutting trench so that the molten metal exits the cutting trench in the same direction as the angle of reflection (α_r) away from the operator, but on the same side of the plane of the metal on which the cutting torch is located;

moving the cutting torch in a direction generally parallel to a desired cut line to expand the cut line; and

varying at least one of the distance from the cutting tip to the metal and the flow rate of the oxygen so as to provide heat making a cut.

6. A method for cutting metal according to claim 5, wherein air said control means for gradually increasing gas pressure comprises an easy-on air lance.

7. A method for cutting metal according to claim 5, wherein the combustible gas is propane and it is adjusted between about 35 to 80 psi.

8. A method for cutting metal according to claim 5, wherein the combustible gas is chemtane and it is adjusted between about 35 to 80 psi.

9. A method for cutting metal according to claim 5, wherein the combustion enhancing gas is oxygen and it is adjusted between about 150 and 220 psi.

10. A method for cutting metal according to claim 5, wherein the combustion enhancing gas is a dual liquid oxygen source.

11. A method for cutting metal from ships, comprising:

heating metal locally to a molten state by holding a cutting torch generally perpendicular to the surface, where the cutting torch with control means has a two-part tip which releases both a combustible gas and a combustion enhancing gas in the same general direction, with the combustible gas adjusted between about 35 to 80 psi and oxygen adjusted between about 150 and 220 psi;

directing the gases at the molten metal at an angle of incidence (α_i) with a plane of the molten steel of at least about 45 degrees and increasing the flow rate of the combustion enhancing gas, thereby removing the molten metal from the local area creating a cutting trench;

maintaining an angle of incidence (α_i) of at least 45 degrees to remove the molten metal from the cutting trench so that the molten metal exits the cutting trench in the same direction as the angle of reflection away (α_r) from the operator, but on the same side of the plane of the metal on which the cutting torch is located;

moving the cutting torch in a direction generally parallel to a desired cut line to expand the cut line; and

varying the distance from the cutting tip to the metal and the flow rate of the oxygen so as to provide heat making a cut.

12. A method for cutting metal according to claim 11, wherein the control means is an easy-on air lance.

13. A method for cutting metal according to claim 11, wherein the two-part tip is size No. 6 through No. 10 cutting tip.

14. A method for cutting steel from ships comprising:

heating steel locally to a molten state by holding a cutting torch generally perpendicular to the surface where the cutting torch is a propane-oxygen cutting torch having a two-part No.8 Propane straight tip which releases both propane and oxygen in the same general direction, with the propane adjusted to about 60 psi and oxygen adjusted to about 200 psi, and having an easy-on air lance;

directing the propane-oxygen gases at the molten steel at an angle of incidence (α_i) with a plane of the molten steel of at least about 45 degrees and increasing the flow rate of the oxygen thereby removing the molten steel from the local area creating a cutting trench;

maintaining an angle of incidence (α_i) of at least about 45 degrees to remove the molten steel from the cutting trench so that the molten steel exits the cutting trench in the same direction as the angle of reflection (α_r) away from the operator but on the same side of the plane of the steel on which the cutting torch is located;

moving the cutting torch in a direction generally parallel to a desired cut line to expand the cut line;

varying the distance from the cutting tip to the steel and the flow rate of the oxygen so as to provide heat making a cut.